

GREEN

Dart Aerospace Ltd.

Date: Wednesday, 10/25/2006 11:14:04 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 29161	Part Number	: D2573		
Estimate Number	: 10533	Drawing Number	: D2573 REV E		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 10/25/2006	S.O. No.	: N/A		
Prsht Rev.	: NC	Drawing Revision	: E		
First Issue	: N/A	Material	: N/A		
Previous Run	: 28804	Due Date	: 11/15/2006		
Written By	:	Qty:	4		
Checked & Approved By	:	Um:	Each		
Comment	: Est: 10 As Per RevE 06-01-27 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: 325354 X4	En 06/10/28
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: B29161 Double check by: <u>DK</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	En 06/10/30 X4
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	En 06/10/30 X4
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	En 06/10/30 X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Am 06/10/30 4

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

POWDER COATING

M18144

Am 06/14/10 ④

7.0 POWDER COATING



Comment: POWDER COATING GREEN

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Yl am 06/11/15 x4

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Bob 11/16 ④

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST480

Bob 06/11/16 ④

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Bob 06/11/16 ④

Job Completion



Locel 11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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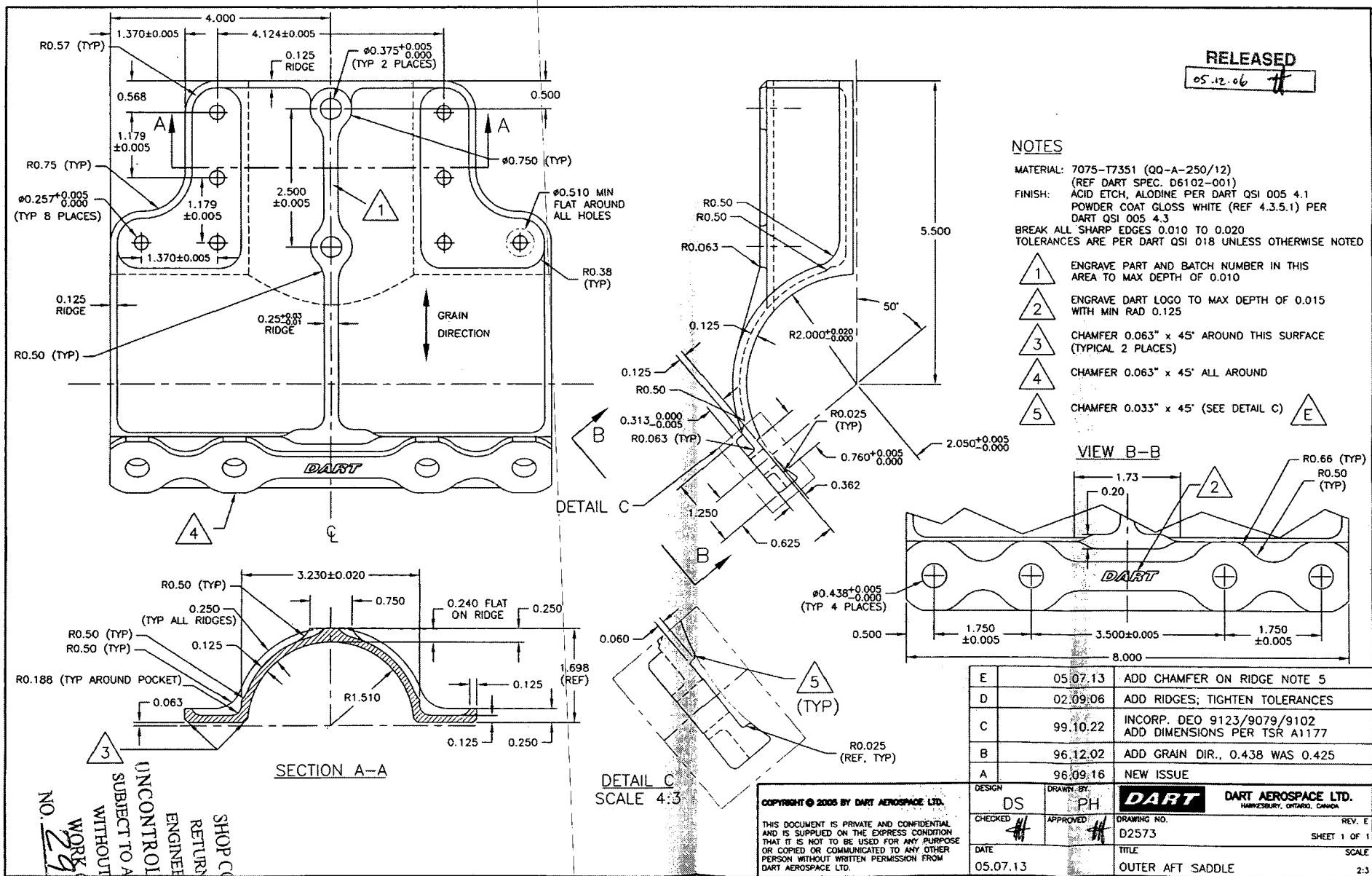
DART AEROSPACE LTD				Work Order: 29161	
Description: Saddle, Aft Outboard		Part Number: D2573			
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.442	0.442	0.442	0.442		
B	1.745	1.755		1.749	1.751	1.751	1.747		
C	3.495	3.505		3.501	3.500	3.499	3.498		
D	1.745	1.755		1.749	1.751	1.751	1.747		
E	7.990	8.010		8.000	8.004	8.004	8.006		
F	0.490	0.510		0.496	0.500	0.498	0.501		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.498	0.503	0.502	0.500		
J	1.174	1.184		1.175	1.178	1.177	1.176		
K	0.558	0.578		0.561	0.568	0.568	0.568		
L	1.174	1.184		1.175	1.178	1.177	1.176		
M	1.365	1.375		1.368	1.371	1.370	1.369		
N	2.495	2.505		2.497	2.499	2.499	2.501		
O	4.119	4.129		4.121	4.122	4.122	4.120		
P	0.115	0.135		0.127	0.129	0.128	0.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.256	0.255	0.255	0.256		
S	0.115	0.135		0.123	0.123	0.120	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.234	0.240	0.240	0.244		
W	0.115	0.135		0.124	0.121	0.121	0.123		
X	0.308	0.313		0.311	0.310	0.310	0.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.370	0.364	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.628	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.250	0.245	0.248		
AE	1.500	1.520		1.512	1.515	1.513	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.252	0.252	0.257		
AI	2.000	2.020		2.003	2.004	2.003	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EN	Audited by:	ML
Date:	06/10/30	Date:	06/10/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	ML



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 NO. 2916

RELEASED

05.12.06 77